

Date: Tuesday, 2/26/2008 7:59:48 AM
User: Kim Johnston

Process Sheet



10

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")	<p>(7)</p> <p>Qty: Um: Each 7 Kits</p>
Job Number : 37603		
Estimate Number : 10323		
P.O. Number :	Part Number : D206559013	
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D2432 REV F3	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : MACHINED PARTS	Drawing Revision : F3	
Previous Run : 37200	Material :	
Written By : <u>JA 080226</u>	Due Date : 3/8/2008	
Checked & Approved By : <u>JA 080226</u>		
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM Est Rev:L 08-01-09 Added Step 2 JLM Verified By:EC		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
		

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005



5 08/04/28 08/02/27

2.0	MFG ENGINEERING	MFG ENGINEERING
		

Comment: MFG ENGINEERING

Program Batch Number

JA 08-01-16

3.0	MUHMWB10	UHMW 1" Black
		

Comment: Qty.: 6.8250 sf(s)/Unit Total : 40.9500 sf(s)


blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: M105863

SD 08/04/27

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		

Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

SB/ 08/04/27

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 7:59:48 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 37603

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A. 08/04/24

(13)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 08/04/25

(14)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total: 15.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

35769

SS 08/04/28

(15)

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

B36624 X15 B37630 X69

SS 08/04/28

(16)

10.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B36624 X34
B37562 X8

Same Batch, need to take out 1 more of this Batch #

SS 08/04/28

(17)

11.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B37210

SS 08/04/28

(18)

QA: N/C Closed: Date: _____

[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 37603

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12 D2529

Washer

12.0

D2732

Rubber Extrusion



72.0

check your



Comment:

Qty.: 10.4160 f(s)/Unit

Total : 62.4960 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

D2732-050 Rubber Cushion

37632

(6 x 5 inches) x 7 Kits = 21 feet

double

I picked 6 x 5 inches x 7 Kits. I took them out wrong in comp. Because of this.

SS 08/04/28 (x7)

13.0

AN415A

Bolt



84.



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M107321

SS 08/04/28 (x7)

14.0

AN417A

Bolt



84.



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M105653

SS 08/04/28 (x7)

15.0

AN960JD416

Washer



168.



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M107321

SS 08/04/28 (x7)

16.0

MS21042L4

Nut



84.



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M106051

SS 08/04/28 x7

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/29 *7A*

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: _____

Rev A

08/04/29 *XL*

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30 *JA*

Job Completion



MF 08-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37603
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063 x 45°	/			
B	5.500	+/-0.030	5.503	/			
C	0.200	+/-0.030	.195	/			
D	0.25 x 45°	+/-0.030	.25 x 45°	/			
E	R0.250	+/-0.030	R.250	/			
F	0.250	+/-0.010	.249	/			
G	0.625	+/-0.030	.620	/			
H	0.375	+/-0.010	.380	/			
I	0.950	+0.030/0.010	.950	/			
J	19.000	+/-0.030	19.00	/		Tape	
K	3.14	+/-0.030	3.14	/			
L	3.28	+/-0.030	3.280	/			
M	Ø0.260	+0.005/-0.000	Ø.260	/			
N	Ø0.93	+/-0.030	Ø.928	/			
O	0.30	+0.030/-0.000	.301	/			
P	23.750	+/-0.030	23.750	/		Tape	
Q	7.375	+/-0.030	7.375	/			
R	4.250	+/-0.010	4.250	/			
S	2.000	+/-0.030	2.000	/			
T	9.000	+/-0.010	9.000	/			
U	9.000	+/-0.010	9.000	/			
V	0.375	+/-0.010	.375	/			

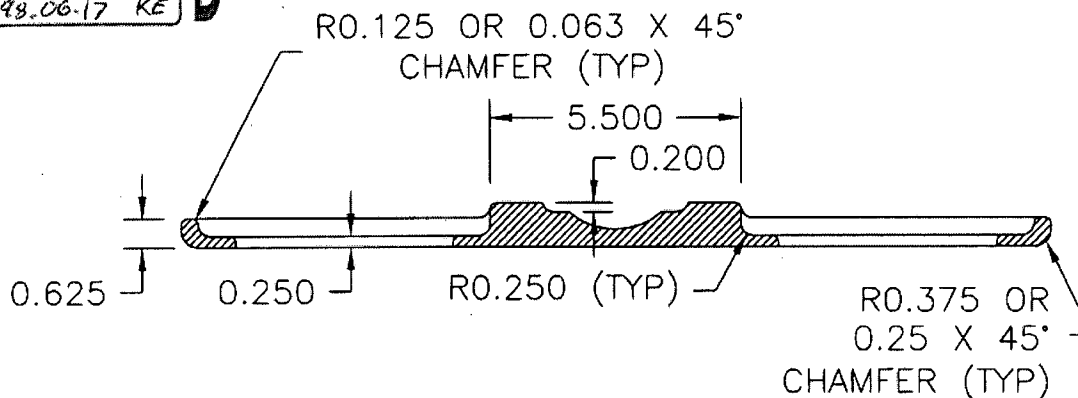
Measured by: SD	Audited by: LJP	Prototype Approval:	N/A
Date: 08/04/21	Date: 08/04/21	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

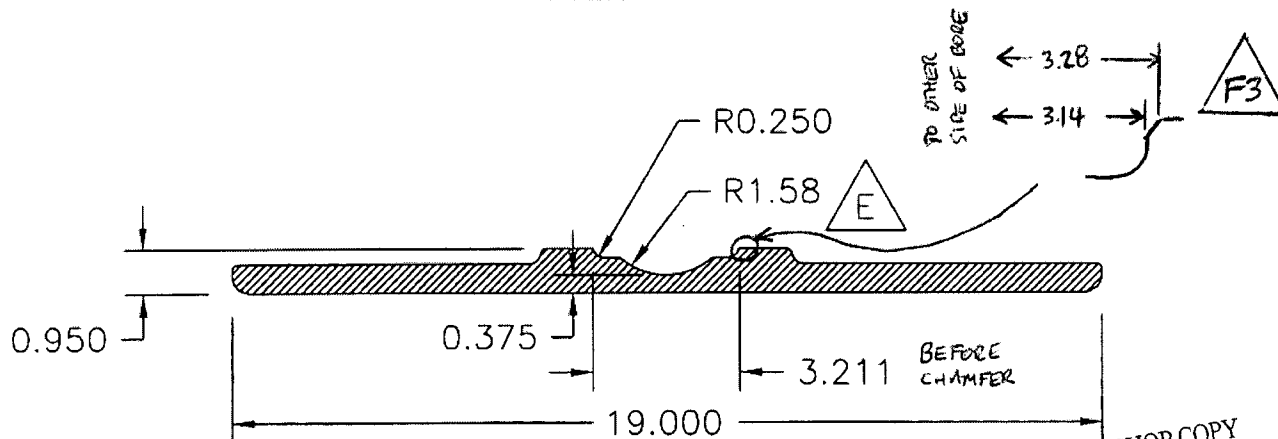


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

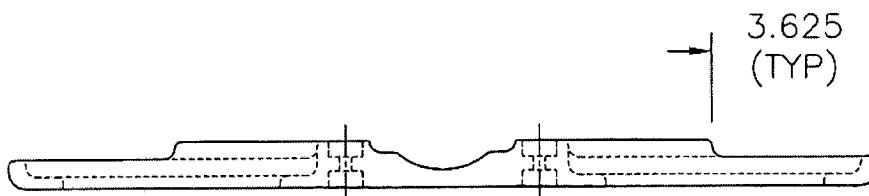
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37603